

Work Order ID 80737

80737

Page 1

February-28-12 10:34:44 AM

Item ID: D4151-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lower Hardpoint Plate
 Start Date: 28/02/2012 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 13/03/2012 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4151	C

100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D4151								
<u>304.125</u>	Prog Rev: <u>C</u>								
	Dwg Rev: <u>C</u>								
	Deburr as required								

B12-3-4

(16)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B12-3-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80737

80737

Page 2

February-28-12 10:34:44 AM

Item ID: D4151-1

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Lower Hardpoint Plate

Stop

NS2

Start Date: 28/02/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 13/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: B4

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

(+16)

12/3/12

16/50

MLJ

12/03/06

MLJ 12/03/06
(14)

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Picklist Print

February-28-12 10:34:48 AM

Page 1

Work Order ID: 80737

80737

Parent Item: D4151-1

D4151-1

Parent Item Name: Lower Hardpoint Plate

Start Date: 28/02/2012

Required Date: 13/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
11.01.21 as per dwg revC DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	51.2000	0.0508	0.641684	1.		

M304S11GA

304/316 0.125 Sheet

**

B 12-3-4

Location

Loc Qty

Loc Code

MAT020

51.2

120243

26

120604

25.2

120604

(16)

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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)

D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

80737 MJS
12/02/28

RELEASED
2011-01-18

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C3-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C3-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.5ED. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/-7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C3-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20815-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2) REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C
SHEET 1 OF 3
TITLE **BASKET FWD HARDPOINT** SCALE NTS

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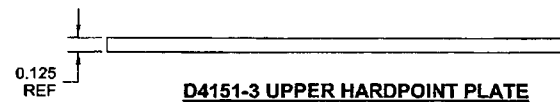
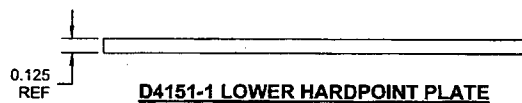
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2011-01-18
JMD

DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			DRAWING NO.	REV. C
CHECKED	SC		D4151	SHEET 2 OF 3
MFG. APPR.			TITLE	SCALE
APPROVED	AM		BASKET FWD HARDPOINT	NTS
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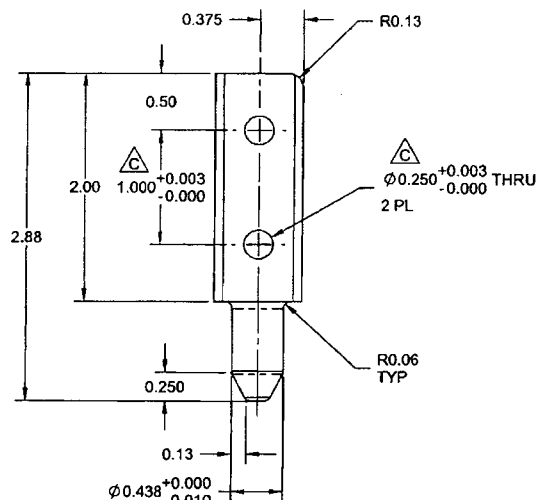
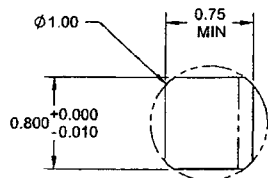
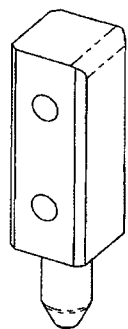
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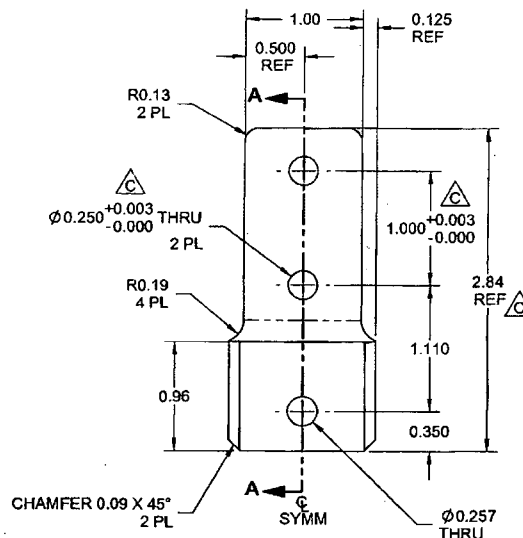
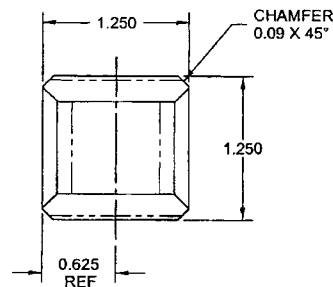
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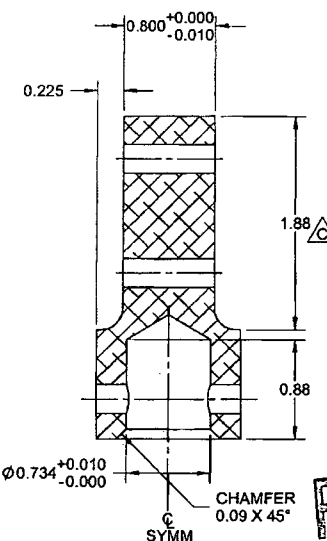
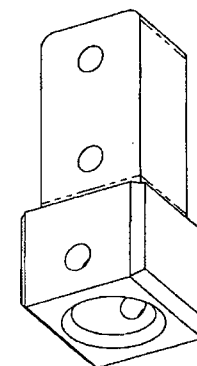
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D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

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DRAWN	Jk	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Sc	DRAWING NO.	REV. C
MFG. APPR.	Sc	D4151	SHEET 3 OF 3
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2011-01-10
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80737

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